



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3301-00
Job Sheet 193195



Part No: RBE350A94-3301-00

Job Qty: 10 pcs

Part Name: Tail Rotor Accelerator Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-3301-00 Rev 4 IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	NV5000 - 1	10 pcs	5/6/19	5/6/19	0.00	20.00	NV5000 - 1 NV5000 - 2	ALA - A.C.C.
120	QC 2	10 pcs	5/6/19	5/6/19	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62 QC 2 - 63 QC 2 - 8 QC 2 - 66 QC 2 - 64	S.C.L. - 19-06-06



Container No: S188042



Part: RBE350A94-3301-00

Job No: 193195

Serial No/Batch: S188042

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/06/19

Plex 4/9/19 11:36 AM Dart.lajeunesse.marie

130	QC 8	10 pcs	5/6/19	0.00	0.00	QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	Δ. = 19-06-07
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
150	Outsource - 4 - Anodize	10 pcs	5/6/19			ATG001-VC	10
160	Packaging 2-1 - Receive - B4B	10 pcs	5/6/19	0.00	0.00	Packaging 2 - 1 - B4B	Δ 209-06-13
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	

					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170	QC 6	10 pcs	5/6/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
180	Packaging 3-1 - Stock - B4B	10 pcs	5/6/19	0.00 0.00	Packaging 3 - 1 - B4B	9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
190	QC 21 - FG	10 pcs	5/6/19	0.00 0.00	QC 21 - FG - 21	21
					QC 21 - FG - 70	9-89 JUN 21 2019
					QC 21 - SA - 53	

Part Op 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FB979 FOLIO REV: AA DWG
 Descriptions: REV: 4 Engrave part number and batch number And T/N number 2-Deburr

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check) Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

150 - Issue P/O to ATG: 43713 - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required

160 - (Receive & Inspect for Damage & Mat'l Certs)

170 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

MAT
used.
~~11.234~~
11.234'

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
649.5013E	Deflector	6.5000 pcs (.65 ea)	110-NV5000 - 1	B92313

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-NV5000 - 1	649.5013E	7	55	0

Part Specifications

Specifications could not be found.

M35

Plex 4/9/19 11:36 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	193195
Description: Tail Rotor Accelerator Support		Part Number:	RBE350A94-3301-00
Inspection Dwg: RBE350A94-3301-00 Rev: 4		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.850	$\pm .005$	1.851	✓		VERN.	
.180	$\pm .005$	.182	✓		VERN.	
.180	$\pm .005$	.178	✓		MIC.	
R.197 Max		R.125	✓		Rad gage	
□.005	.005	0.0044	✓		indicator	
7.677	$\pm .005$	7.678	✓		VERN.	
1.181	$\pm .005$	1.182	✓		VERN.	
R.20	$\pm .010$	0.200	✓			
.394	$\pm .005$	.393	✓		VERN.	
.236	$\pm .005$	.236	✓		VERN.	
.236	$\pm .005$	.236	✓		VERN.	
Ø.218	$\pm .005$	.218	✓		gage pin	
Ø.079	$\pm .005$	.081	✓		gage pin	
77°	$\pm .5°$	77°	✓		gage	
Ø.276	$\pm .005$	.276	✓		gage pin	
R.315	$\pm .005$	0.315	✓			
R.787	$\pm .005$	0.787	✓			
1.619	$\pm .005$	1.619	✓			
1.535	$\pm .005$	1.534	✓		VERN.	
.591	$\pm .005$	.590	✓		VERN.	
.349	$\pm .005$	0.349	✓			
.869	$\pm .005$	0.869	✓			
30°	$\pm .5°$	30°	✓		gage	
.197	$\pm .005$	0.197	✓			
.473	$\pm .005$	.472	✓		Height gage	
1.968	$\pm .005$	1.967	✓		Height gage	
1/4-28		OK			go no-go	

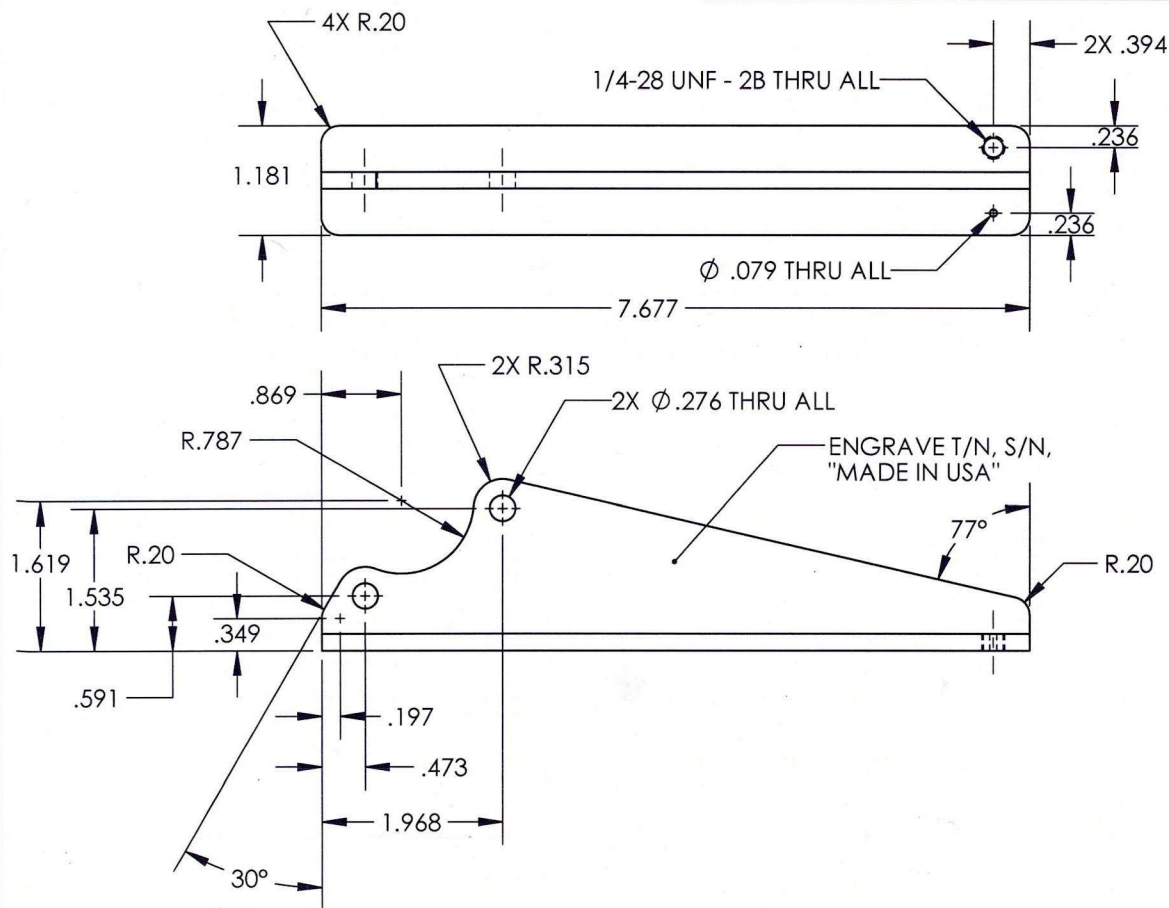
Measured by: ALA./sc/L	Checked by: D.P.	QC Inspector:
Date: 19-06-06	Date: 19-06-07	Date:

Engineering Approval: (If necessary)	Date:
---	-------

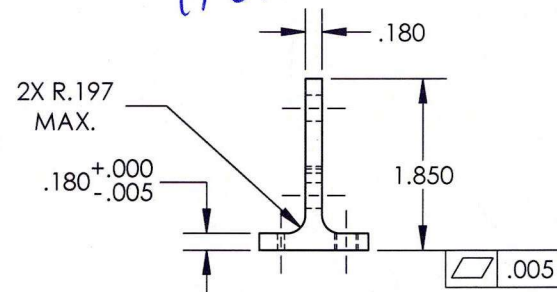
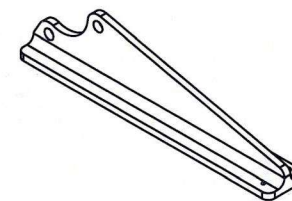
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/9/2009	WP	DW
1A		ADDED MISSING DIMENSIONS, ADDED ENGRAVE NOTE PER R.W.	9/15/2011	RJC	RW
2		CORRECTED DIMENSION FROM .676 TO .667, ADDED OPTIONAL TO R.197 DIMENSION, ADDED FLATNESS CONTROL TO BOTTOM OF TOOL, CH'D MATERIAL FROM 2024 T-BAR PER R.W.	5/9/2012	RJC	RW
2A		CH'D T/N WAS RBEA94-3301-00 IS RBE350A94-3301-00.	11/6/2013	RJC	RW
3		CH'D DIM WAS .188 IS .180 +.000/-.005.	4/11/2014	DPD	GE
4	16-0256	CH'D DIM WAS .180 +.000/-.005 IS .180 WAS 4X R.197 IS 4X R.20, WAS R.197 IS R.20 IN TWO PLACES, WAS 1/4-28 UNF IS 1/4-28 UNF -2B THRU ALL, WAS Ø.079 IS Ø.079 THRU ALL, WAS 2X Ø.276 IS 2X Ø.276 THRU ALL, WAS 2X R.197 OPTIONAL IS 2X .197 MAX, DELETED DIMS Ø.250 TOOLING HOLE, 5.750, .667, CH'D MATERIAL WAS 6063 T CHANNEL IS 6063.	12/6/2016	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193195 MJS
19-04-09



DART AEROSPACE	
TITLE T/R ACCELERATOR SUPPORT	
DWG NO. RBE350A94-3301-00	REV 4
MAT'L 6063	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AS350/AS355
SCALE 1:2	DATE 9/9/2009
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1		6063		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043713



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043713

PO Date: 6/13/19

Due Date: 6/27/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-06-17

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195895	D2224	Rappel Anchor Assembly : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O: Red Anodize as per Dwg D2224 MIL-A-8625	Firmed - X10	-	6/27/19	10 pcs	0 pcs	10 pcs	\$9.37/pcs	\$93.70
2	196219	RBD29904	Hoist Adapter "D" Model -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed -	-	6/27/19	1 pcs	0 pcs	1 pcs	\$9.37/pcs	\$9.37
3	194194	RBT400203-K	Weldment -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -	-	6/27/19	4 pcs	0 pcs	4 pcs	\$9.37/pcs	\$37.48



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043713



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193195	RBE350A94-3301-00	Tail Rotor Accelerator Support -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	6/27/19	17 pcs	0 pcs	17 pcs	\$9.38/pcs	\$159.46
Grand Total:											\$300.01

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/17/19 9:44 AM Dart. Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918021

Date: 18-Jun-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
17 ea	Part: RBE350A94-3301-00 Tail Rotor Accelerator Support Clear Anodize per MIL-A-8625F, Type II, Class 1, Water Seal .0004-.0010" (4 - 1 mils). Job: 25333 PO: POHB043713	Rev: 4 Line: 4	DAS 61 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUN 18 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

RECEIVED

JUN 19 2019

DART AEROSPACE LTD.